

Work Order ID 51102

August 4, 2009 8:20:15 AM



Page 1

Item ID: D2012-105

Accept



Setup Start



Revision ID: E

Stop



Item Name: Arm

Start Date: 08/04/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-08-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2012-105

Rev

~~E~~ *MF*

100



Brake NC

Brake NC

NC BRAKE

Memo

Punch to length as per Dwg D2012-105 & template D2012-105T1

0.00

0.00

M-L 09/08/04

PTC

110



Small Fab

Small Fab

Small Fab

Memo

1-Debur

0.00

0.00

M-L 09/08/04

10X

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

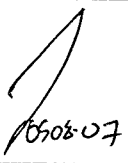

0.00

=> S 09/08/05

(100)

100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-08-07	W/O Header	Dwg is now up to Rev. E. update w/o dwg Rev. perm change	EE	09-08-10		 05-08-07	 05-08-07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:00 AM

M109091 09-08-05

(X10) JF

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-08-5

(10)

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

9/8/5 10x 34

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-08-07
UNF 09-08-06 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 4, 2009 8:20:15 AM

Page 1 / 1

Work Order ID: 51102



Parent Item: D2012-105RevE



Parent Item Name: Arm

Start Date: 08/04/2009

Required Date: 08/05/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	358.5862	27.6358			



304 RD Tube .500 x .035W



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	358.5862097	
108250	2.23	
111097	24.687936	
111704	31.6682737	
112187 ✓	300	

M 112187
M-1 08/08/09

W/O:		WORK ORDER CHANGES					
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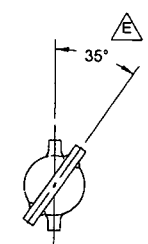
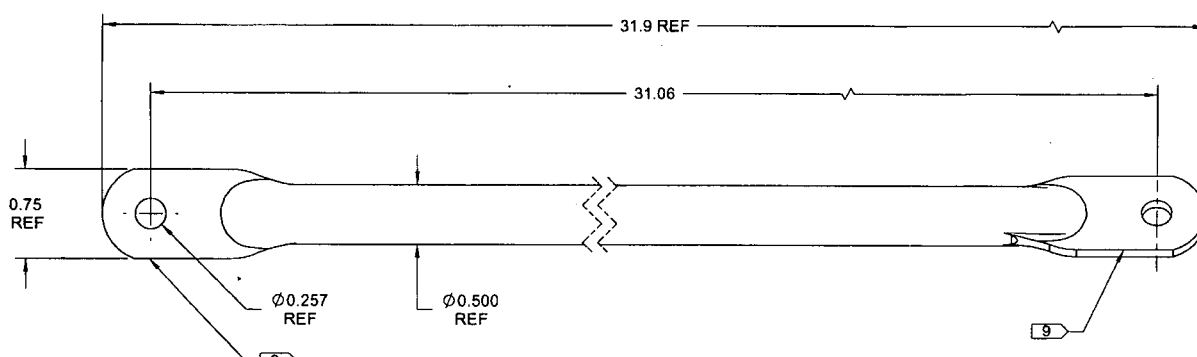
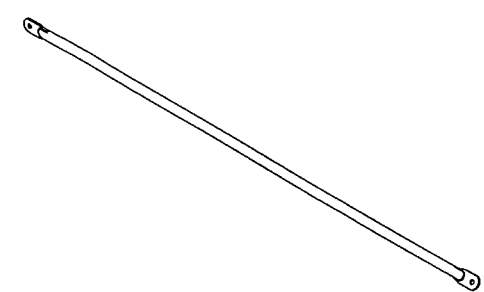
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NOTE: Date & initial all entries

51102
Mf
09-08-04



D2012-105 ARM

RELEASED
9/12/04

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\varnothing 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
- 7) WEIGHT: 0.47 lbs
- 8) MAKE PER TEMPLATE DT8116
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-080	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2012-105 REV. E ARM SHEET 1 OF 1 SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	DATE 09.06.04	

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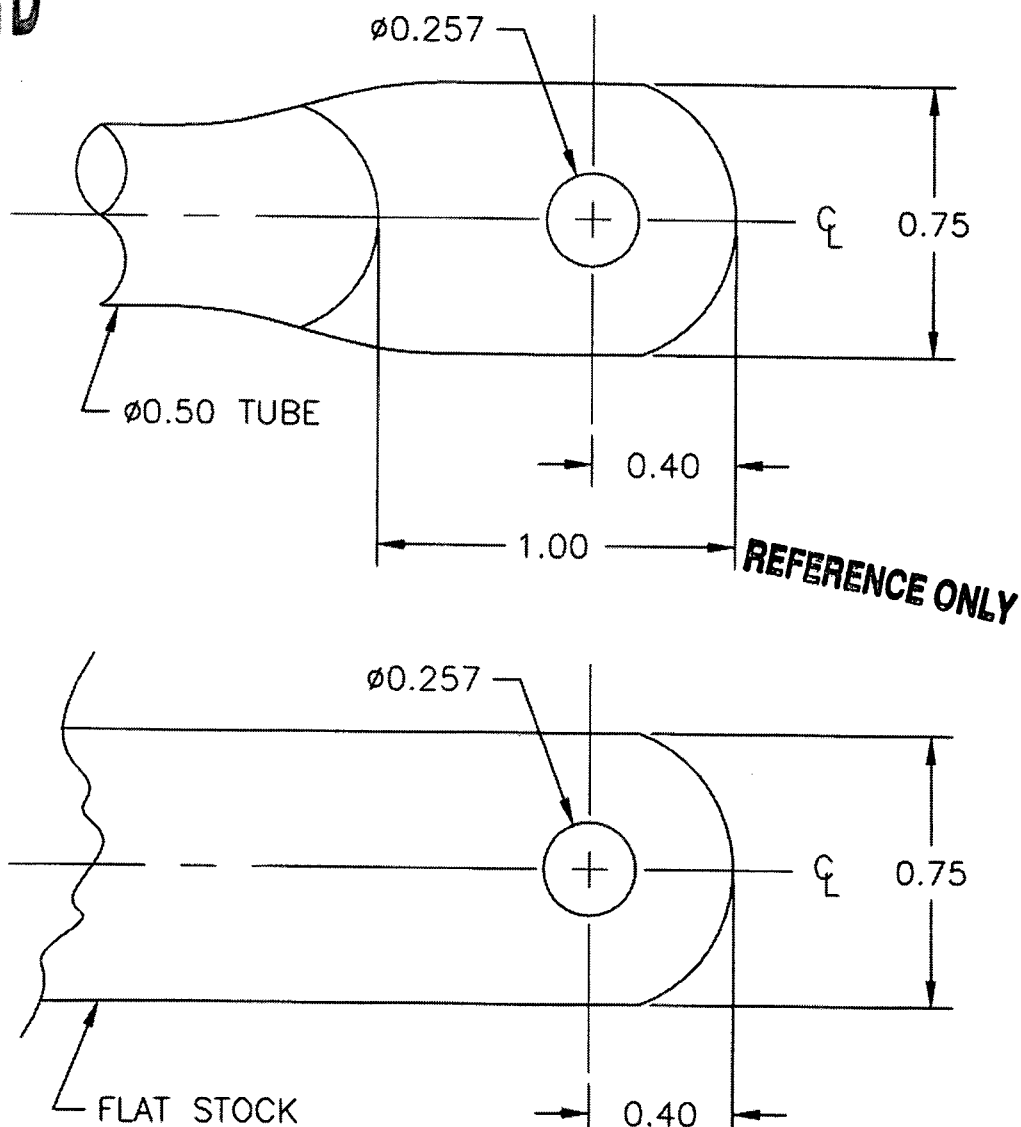
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DMM	APPROVED CA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#1P 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

